

D206-642-512

Dart Aerospace Ltd.

Date: Wednesday, 29/04/2009 10:27:30 AM
 User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|---------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FLOAT SKIDTUBE ASSEMBLY |
| Job Number | : 47589A | | |
| Estimate Number | : 10309 | | |
| P.O. Number | : | Part Number | : D206642541 |
| This Issue | : 29/04/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3274 REV D |
| First Issue | : 29/04/2009 | Project Number | : N/A |
| Previous Run | : 47588A | Drawing Revision | : D |
| | Type : SKIDTUBES | Material | : |
| Written By | : | Due Date | : 10/05/2009 |
| Checked & Approved By | : <u>JD 09.04.29</u> | Qty: | 1 Um: Each |
| Comment | : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD Est Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC Est Rev:F 08-06-02 add comment DD verified by:EC Est Rev:G 08-10-09 revise details DD verified by:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A

| | | |
|-----|-----------|------------------------|
| 2.0 | D26001190 | Extrusion Round 3" 206 |
|-----|-----------|------------------------|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2600-1-190 3" OD Tube

31032

BT 09-04-29

| | | |
|-----|--------|-----|
| 3.0 | D32851 | Cap |
|-----|--------|-----|

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1 Fwd Cap

247635

BT 09/04/30

| | | |
|-----|-------------|-----------------------|
| 4.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|

**Comment:** LANDING GEAR RESOURCE 1

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

BT 09-04-29

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BT 09-04-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 47589A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

M110972/m109213 BE 09/04/30

4- grind fwd cap weld on top surface only

BE 09/04/30

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

pm 09-05-05

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

pm 09-05-05

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9-5-5

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9-5-5

8.0

D3282041

Float Web (206L/407)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B45304

pm 09-05-05

9.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

pm 09-05-05

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

m111081

Sikaflex expire date:

10-01-20

Start: 09-05-05

Time: 12:30

Finish: 9-5-06

Time: 7AM

(Adhere for 12 hours)

Am
09-05-05 @

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD

9-5-06

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

DP 9-5-06

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

Am 09-05-06 @

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

h=3.0
2°=4.5°

809/05/07 @

13.0

D2649

Cross Bolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

B45317

8E 09/05/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number: 47589A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

BE 09/05/07
B 47464 (11 R) B 47634 (1 R)

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

n109213 BE 09/05/07

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

pm 09-05-08 (1)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/11 (40)

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/05/11 (40)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

11 09-05-11 (21)

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:00

OVEN TEMPERATURE:

320°

FINISH TIME:

2:30

FL 09/05/11 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number: 47589A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



41



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-12

CV

21.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate B33842

41

22.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M111548

41

23.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M15984

41

24.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Insert

Batch: M108606

41

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 M109956

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

41 09-05-12 EC

Dart Aerospace Ltd

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Job Number: 47589A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

M111081

Sikaflex expire date:

10/20

9/1 09-05-12 (XL)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

Sork/13 (X)

27.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

BOLT

Batch:

M111572

9/1

28.0

D353515

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B42249

9/1

29.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B44648

9/1

30.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B39233

9/1

31.0

D353539

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B44645

9/1

32.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B40287

9/1

09-05-12 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| Seq. #: | Machine Or Operation: | Description : |
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|---------|-----------------------|---------------|

| | | |
|------|---------|--------|
| 33.0 | D353623 | Gasket |
|------|---------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 44646

ju

| | | |
|------|---------|--------|
| 34.0 | D353635 | Gasket |
|------|---------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 46885

ju

| | | |
|------|---------|--------|
| 35.0 | D353639 | Gasket |
|------|---------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B 44648

ju

| | | |
|------|--------|---------|
| 36.0 | D35371 | Wearpad |
|------|--------|---------|



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: (4x) 47205 (5x) B47530

ju

| | | |
|------|--------|---------|
| 37.0 | D35373 | Wearpad |
|------|--------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: 1333881

ju

| | | |
|------|-----------|--------|
| 38.0 | AN960C10L | washer |
|------|-----------|--------|



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer M111548

ju

| | | |
|------|--------|-----------------|
| 39.0 | D36721 | Phenolic Washer |
|------|--------|-----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch 1339275

ju

08-05-12

ED

| W/O: | | WORK ORDER CHANGES | | | | | |
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Seq. #:

Machine Or Operation:

Description :

40.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B33949 *ees*

41.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M110552 *el*

42.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer M100493 *el*

43.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B46327 *el*

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291 M 111081

Sikaflex expire date: 10/20

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

X A/R LPS-3 Batch: 101A

el 09-05-12 EL

| W/O: | | WORK ORDER CHANGES | | | | | |
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

✓ A/R Sikaflex-291 M111081

Sikaflex expire date: 10/20

HP 09-05-12 (T)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/13 (X)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: PPD 47589 PC 9/5/13 (1)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/13 HP

Job Completion



4 09-05-13

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN CP | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3274 | REV. D SHEET 1 OF 4 |
| DATE 06.12.19 | | TITLE SKIDTUBE ASSEMBLY SCALE NTS | |
| A | 04.03.15 | NEW ISSUE | |
| B | 04.08.09 | MOVE SADDLE HOLE: 42.14 WAS 42.76 | |
| C | 05.03.16 | ADD -043; NEW INSERTS | |
| D | 06.12.19 | NEW INSERTS, SS WEARSHOE + GASKET | |

RELEASED**07.02.12** **[Signature]**

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|---------------|---|
| X | | D3274-041 | SKIDTUBE ASSEMBLY |
| | X | D3274-043 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2600-1-240 | EXTRUSION |
| 1 | 1 | D2646 | AFT CAP |
| 12 | 12 | D2649 | CROSS BOLT SPACER |
| 12 | 37 | D3275-1 | CROSS BOLT SPACER |
| 1 | 1 | D3282-041 | FLOAT WEB |
| 1 | 1 | D3285-1 | CAP |
| 1 | 1 | D3413-1 | RING |
| 1 | 1 | D3415-041 | NUT PLATE |
| 1 | 1 | D3535-15 | WEARSHOE |
| 1 | 1 | D3535-23 | WEARSHOE |
| 1 | 1 | D3535-35 | WEARSHOE |
| 1 | 1 | D3535-39 | WEARSHOE |
| 1 | 1 | D3536-15 | GASKET |
| 1 | 1 | D3536-23 | GASKET |
| 1 | 1 | D3536-35 | GASKET |
| 1 | 1 | D3536-39 | GASKET |
| 9 | 9 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-3 | WEARPAD |
| 78 | 78 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130) |
| 80 | 80 | AN3C4A | BOLT |
| 1 | 1 | AN4C5A | BOLT |
| 1 | 1 | AN960C416 | WASHER |
| 80 | 80 | AN960C10L | WASHER |
| 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | NAS1515H3L | WASHER |

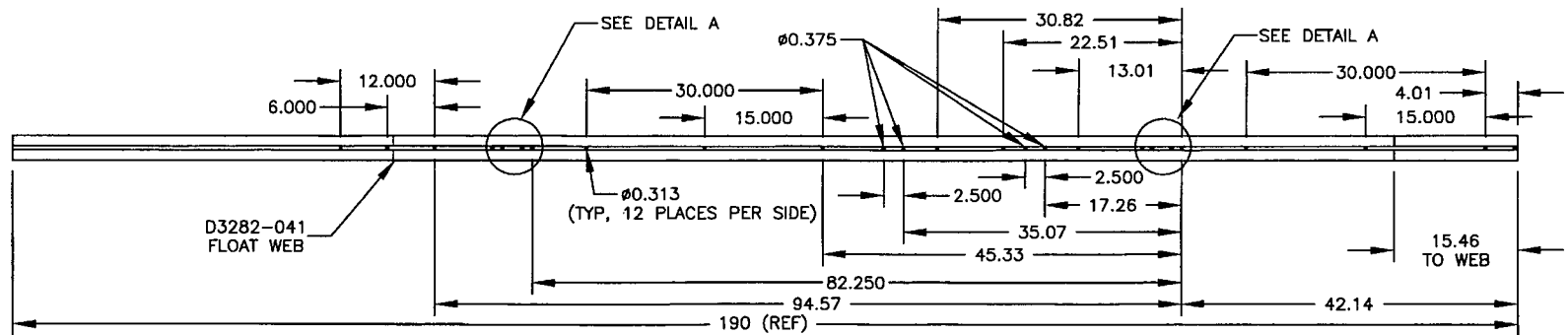
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

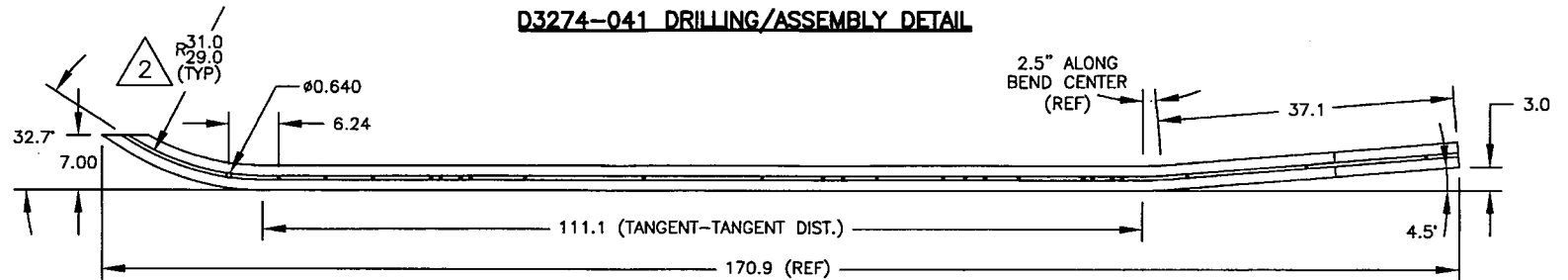
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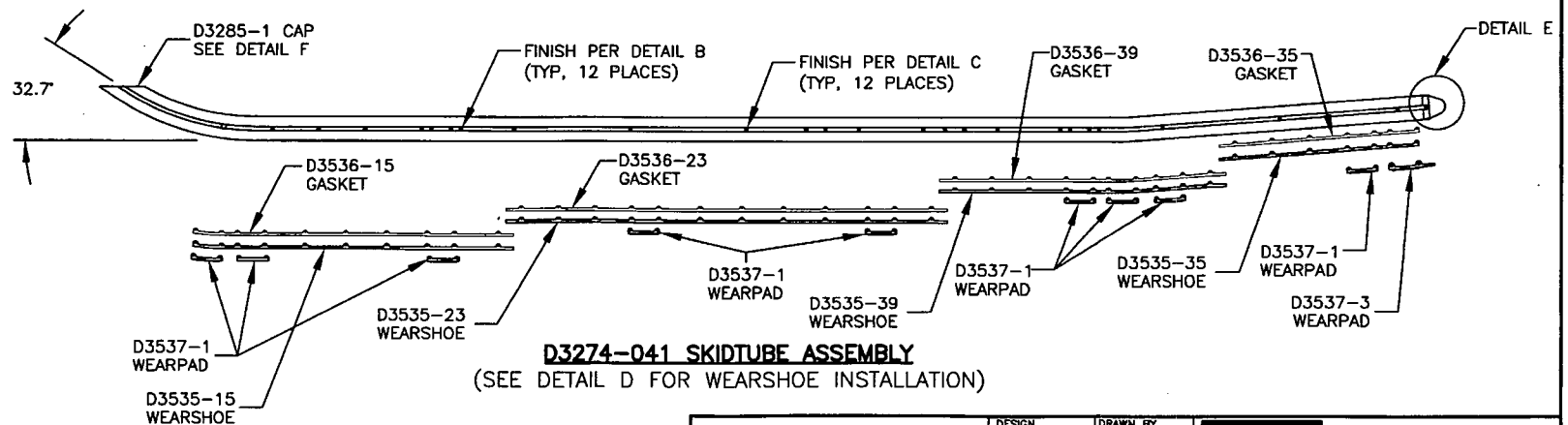
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

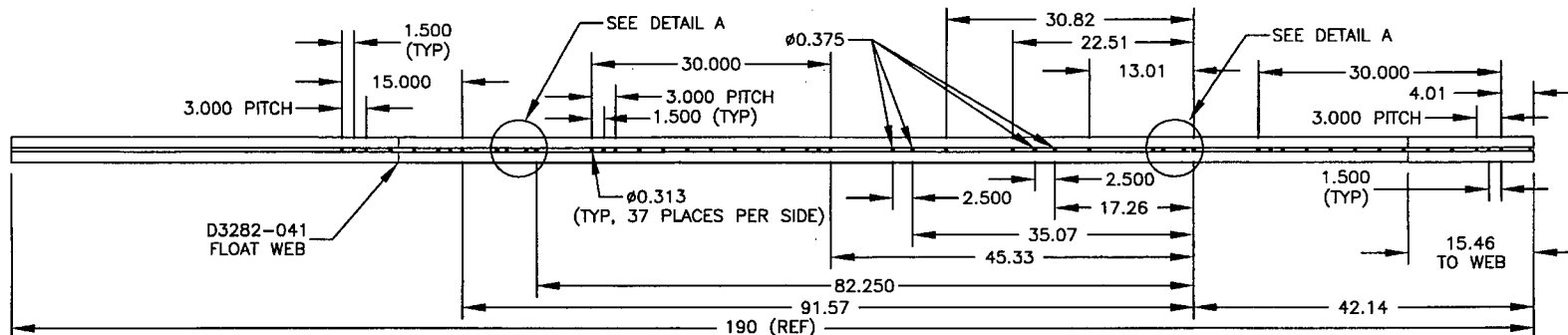
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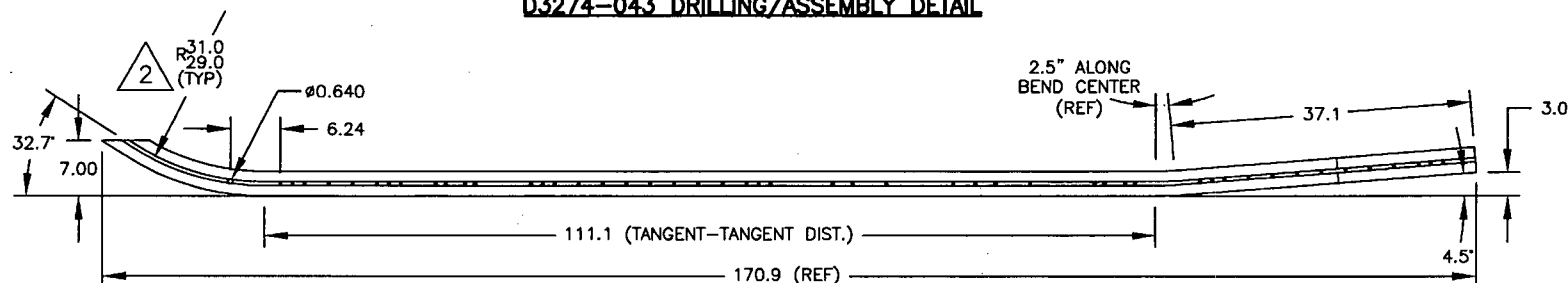
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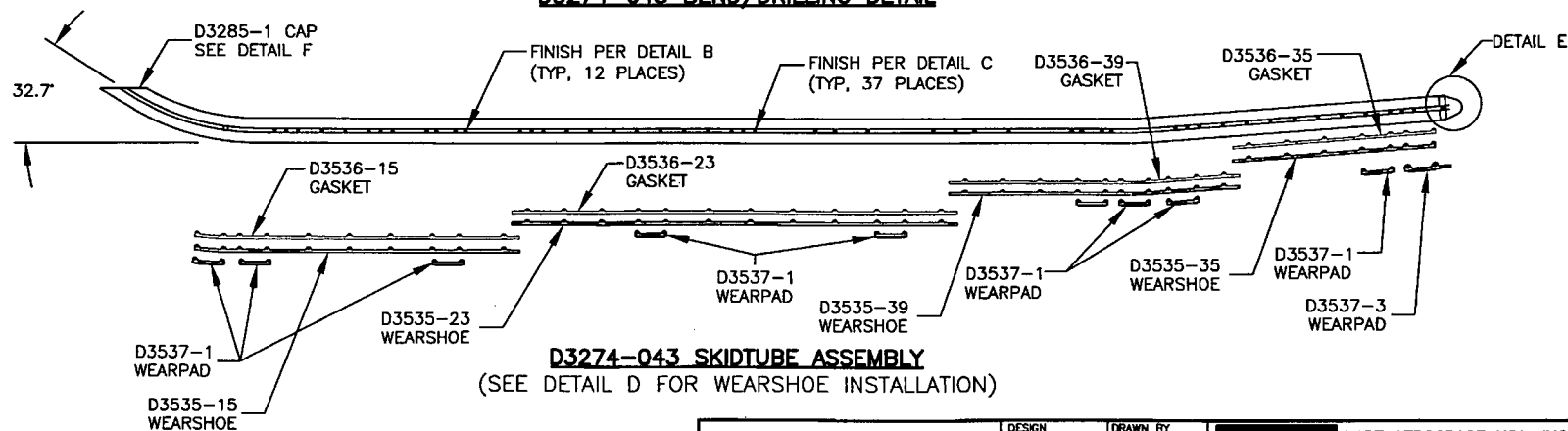
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| DESIGN | CP | DRAWN BY | PH | DART DART AEROSPACE USA, INC. PORT HADLOCK, WA | REV. D |
| CHECKED | # | APPROVED | # | DRAWING NO. D3274 | SHEET 2 OF 4 |
| DATE | 06.12.19 | TITLE | SKIDTUBE ASSEMBLY | SCALE | 1:15 |



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

| | | | | | | | |
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| | | DATE | 06.12.19 | | | D3274 | SHEET 3 OF 4 |
| | | | | | | SKIDTUBE ASSEMBLY | SCALE 1:15 |

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7-07-02

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WORK SHEET
NO. 27980918

Ø0.375 (TYP)

3.750

5.000

1.250

D2649 SPACER

AFTER DRILL
PERFORM THE
HOLES ONLY

AFTER DRILLING AND BENDING ASSEMBLY
 PERFORM THE FOLLOWING FOR Ø0.375
 HOLES ONLY:
 1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

D3275-1 SPACER

CHAMFER 0.030x45°
(TYP)

DETAIL D

- ALS7-1032-130 INSERT (1)
- AN3C4A BOLT (1)
- AN960C10L WASHER (1)
- (78 PLACES)
- GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

Ø0.208 (2 PLACES)
PRIOR TO
INSTALLING
D2646 CAP

0.400

AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291

CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

1/16

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NEEDED)
4. WELD D3285-1 IN PLACE PER D
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN

NOTE: MASK THREADS IN D3415-0

| QTY | PART NO. | DESCRIPTION |
|-----|-------------|-------------|
| 1 | AN4C5A | BOLT |
| 1 | AN960C416 | WASHER |
| 2 | CCR264SS3-3 | RIVET |
| 2 | CR3212-4-03 | RIVET |
| 1 | D3415-041 | NUT PLATE |
| 1 | D3413-1 | RING |
| 1 | D3285-1 | CAP |

RELEASED
07.02.12 #

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
Z C Z D2646 CAP

RECEIVED
FBI
JAN 25 1981
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JAN 25 1981

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CF

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DRAWN BY PH

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

CHECKE

APPROVED

DRAWING NO.

REV. D

| | |
|------|----------|
| DATE | 06.12.19 |
|------|----------|

| | |
|-------|-------------------|
| TITLE | SKIDTUBE ASSEMBLY |
|-------|-------------------|

SCALE
1:3

1:3

NO. 198

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 47288A
Part number: D206 642 545
Description: 206 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pet. Dault Date of Test Coupon 09.04.27
Welder Barclay Elliott Date of Test Coupon 09.04.27

The above named individual is qualified in accordance with AWS D17.1.2001 to weld